

5/03

DART AEROSPACE LTD	Work Order:	22078
Description: Bracket	Part Number:	D3209-041
Dwg: D3209 Rev. A	Qty:	4

Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Dwg not required	JH	04/12/08	4
2	MV	Cut blanks: 1.500" x 1.250" x 1.950" long Bar (+0.030/-0.000) Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11 or QQ-A-225/8) (M6061T6B1.500x01.250) Identify for D3209-1			
3	MV	Machine D3209-1 as per Folio FA345 and Dwg D3209 Identify as D3209-1	JL	04/12/13	4
4	QC2	Inspect parts as they come off the CNC machine	JL	04/12/13	4
5	MV	Deburr and Tumble	JL	04/12/13	4
6	QC8	Second check	JL	04/12/13	4
7	FP	Chemical conversion Coat as per QSI 005 4.1	JL	04/12/13	4
8	FP	Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 Note: Cover the hole for D3209-1 before powder coat.	JL	04/12/13	4
9	QC3	Inspect Powder Coat	JL	05/01/11	4
10	GA	Press fit bushing into the bracket as per Dwg D3209 Pick: Packing Kit Qty Part Number Description Batch 1 D3209-3 Bushing B2208C	JL	05/01/11	4
11	QC5	Inspect work to Step 10	RF	05/01/20	4
12	ST	Identify and Stock	JL	05/01/20	4
13	AC	Cost / part: <u>44.84</u>	SAC	05-01-21	4
14	DC	Close W/O <u>55.28</u> Inspect Level 21	JH	05/01/24	4

Rev	Date	Change	Revised By	Approved
A	04.06.09	New issue	KJ/RF	H

RELEASED

04.06.21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Dec 06, 2004
11:09 am

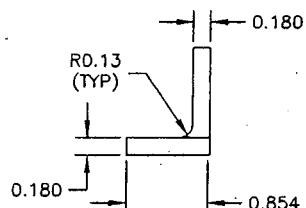
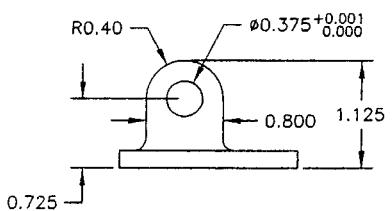
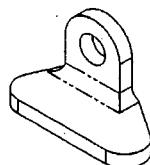
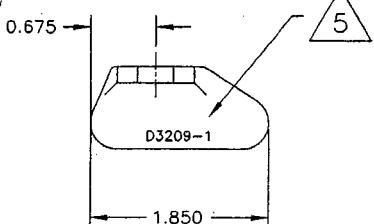
Work Order No	:	0022078	Department Code:	
Project Name	:	D3209-041	Burden Flags	
Project For	:	WK503	WO Status	
Work Order Type	:	Main	Invoice State	
Main WO Number	:		Not Invoiced	
House Part Number	:	D3209-041	Invoice Date	
Description	:	Bracket	Invoice Number	
Manufactured	:	Yes	Invoice Amount	0.00
Amount Req'd	:	4		
Amount Done	:	0	Order Entry No	
Start Date	:	12-06-04	OE Value	0.00
Est Finish Date	:	01-15-05	Est Margin	0.000%
Act Finish Date	:		Actual Margin	0.000%
Drawings Req'd	:	No	\$0 Posted to Finished Goods	
Ok for Approval	:			
Approval Rec'd	:			

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
<hr/>					
Burden	: 0.00	0.00	0.00		
<hr/>					
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

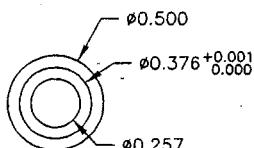
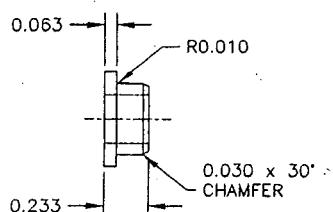
	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/ (Loss)	: 0.00	0.00

DARTCOPY ISSUE
C-0**CONTROLLED COPY**

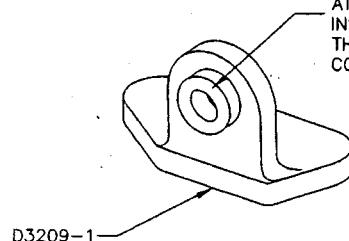
DESIGN <i>RF</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3209	REV. A SHEET 1 OF 1
DATE 04.01.27		TITLE BRACKET	SCALE 1:2
		A 04.01.27	NEW ISSUE

RELEASED
04.04.05 *[initials]*

2 D3209-1 BRACKET



D3209-3 BUSHING
PRESS FIT, HEAD
AT THIS FACE
INSTALL AFTER
THE CONVERSION
COAT



**3 D3209-3 BUSHING
SCALE 1:2**

4 D3209-041 ASSEMBLY

D3209-1 BRACKET; D3209-3 BUSHING

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
ALUMINUM BAR (M6061T6B)
- 3) MATERIAL: AISI 303 SS (M303R)
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 5) ENGRAVE DART P/N AS SHOWN
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE INCHES

DART AEROSPACE LTD	Work Order:	22078
Description: Bracket	Part Number:	D3209-1
Inspection Dwg: D3209 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>gml</u>	Audited by:	<u>EP</u>	Prototype Approval:	<u>N/A</u>
Date:	<u>04/21/13</u>	Date:	<u>04/21/13</u>	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	